

HUHTAMAKI FOOD SERVICE, INC.)	DEPARTMENTAL
KENNEBEC COUNTY)	FINDINGS OF FACT & ORDER
WATERVILLE, MAINE)	PART 70 AIR EMISSION LICENSE
A-416-70-A-I)	

After review of the Initial Part 70 License application, staff investigation reports and other documents in the applicant's file in the Bureau of Air Quality, pursuant to 38 M.R.S.A., Section 344 and Section 590, the Department finds the following facts:

I. REGISTRATION

A. Introduction

FACILITY	Huhtamaki Food Service, Inc. (Huhtamaki)
LICENSE NUMBER	A-416-70-A-I
LICENSE TYPE	Initial Part 70 License
SIC CODES	2679
NATURE OF BUSINESS	molded paper products
FACILITY LOCATION	242 College Ave., Waterville
DATE OF LICENSE ISSUANCE	January 14, 2002
LICENSE EXPIRATION DATE	January 14, 2007

B. Emission Equipment

The following emission units are addressed by this Part 70 License:

EMISSION UNIT ID	UNIT CAPACITY	STACK #	UNIT TYPE
No. 2 Boiler	29.3 MMBtu/hr	1	Fuel Burning
No. 3 Boiler	29.3 MMBtu/hr	1	Fuel Burning
No. 4 Boiler	44 MMBtu/hr	2	Fuel Burning
No. 5 Boiler	64.8 MMBtu/hr	2	Fuel Burning
Stationary Internal Combustion Engine (SICE); Fire Pump	1.22 MMBtu/hr	SICE	Fuel Burning
B-8 Dryer	-	-	Process Equipment
B-9 Dryer	-	-	Process Equipment
B-10 Dryer	-	-	Process Equipment
B-11 Dryer	-	-	Process Equipment
B-12 Dryer	-	-	Process Equipment
B-13 Dryer	-	-	Process Equipment
B-14 Dryer	-	-	Process Equipment

B-15 Dryer	-	-	Process Equipment
Bead Blasters	-	-	Process Equipment
Sodium Hypochlorite Tank	-	-	Storage Tank
Parts Washers	-	-	Process Equipment

Huhtamaki has additional insignificant activities which are not required to be listed in the emission equipment table above. The list of insignificant activities can be found in the Part 70 license application and in Appendix B of Chapter 140 of the Department's Regulations.

C. Application Classification

The application for Huhtamaki (formerly known as The Chinnet Company) does not include the licensing of increased emissions or the installation of new or modified equipment, therefore the license is considered to be an Initial Part 70 License issued under Chapter 140 for a Part 70 source.

II. EMISSION UNIT DESCRIPTION

Facility Description

Huhtamaki is a manufacturing facility that uses recycled food board, newspaper, milk carton stock and other similar paper materials to produce pulp products. Cellulose fibers are mechanically cleaned and vacuum-drawn from a liquid slurry onto pre-shaped wire dies, where they are formed, compressed and dried into finished products. Finished products include paper plates, pizza trays, food trays, and other similar laminated products.

A. Boiler No. 2, 3, 4, and 5

Unit Size and Age

Boiler #2 is a Babcock and Wilcox boiler installed in 1959 with a maximum design operating capacity of 29.3 MMBtu/hr (195.3 gallons/hr) firing #6 fuel oil.

Boiler #3 is a Babcock and Wilcox boiler installed in 1950 with a maximum design operating capacity of 29.3 MMBtu/hr (195.3 gallons/hr) firing #6 fuel oil.

Boiler #4 is a Babcock and Wilcox boiler installed in 1960 with a maximum design operating capacity of 44 MMBtu/hr (293.3 gallons/hr) firing #6 fuel oil. Boiler #4 was licensed to fire wood pellets; however, all equipment used to fire wood pellets has been removed from the facility.

Boiler #5 is a Babcock and Wilcox boiler installed in 1966 with a maximum design operating capacity of 64.8 MMBtu/hr firing #6 fuel oil.

Propane and diesel are used to start up the boilers. Specification waste oil is also mixed with No. 6 oil in the oil storage tank.

The boilers were installed prior to the New Source Performance Standards (NSPS) Subpart Dc applicability date.

NO_x RACT Requirements

Chapter 138 of the Maine Air Regulations requires that every source which has the potential to emit equal to or greater than 100 tons per year apply NO_x RACT to their applicable NO_x emissions. Chapter 138 NO_x RACT requirements are incorporated into this initial Part 70 license.

NO_x RACT for boilers No. 2 and 3 is complying with Section 3(L)(1) & (2) of Chapter 138, which includes recordkeeping requirements and documentation of annual tune-ups.

NO_x RACT for boiler No. 4 will comply with Chapter 138 Section 3(L)(1) & (2), if the boiler operates at greater than 2% of its annual capacity factor.

NO_x RACT for boiler No. 5 is the retrofit of the boiler with low-NO_x burner technology designed to minimize NO_x emissions.

Streamlining

Opacity

Huhtamaki accepts streamlining for opacity requirements. Chapter 101 and Best Practical Treatment (BPT) requirements are applicable. The BPT opacity limit is more stringent. Therefore, only the more stringent BPT limit is included in this license.

Particulate Matter

Huhtamaki accepts streamlining for particulate matter requirements. MEDEP Chapter 103 and Best Practical Treatment (BPT) requirements are applicable. The BPT particulate matter limit is more stringent. Therefore, only the more stringent BPT particulate matter limit is included in this license.

Sulfur Dioxide

Huhtamaki accepts streamlining for sulfur dioxide requirements. Chapter 106 and BPT requirements are applicable. The BPT limit for sulfur dioxide is more stringent. Therefore, only the more stringent BPT sulfur dioxide limit is included in this license.

Periodic Monitoring

Periodic monitoring shall consist of recordkeeping, which includes records of inspection of pollution control equipment and of fuel use through purchase receipts indicating amount (gallons) and percent sulfur and nitrogen content by weight.

Based on the type and amount of fuel for which the boilers were designed and operating in a manner consistent with good air pollution control practices, it is unlikely the boilers will exceed the opacity limits. Therefore, periodic monitoring by the source for opacity in the form of visible emissions testing is not required. However, neither the EPA nor the State is precluded from performing its own testing and may take enforcement action for any violation discovered.

B. Stationary Internal Combustion Engines

Unit Size and Age

Stationary Internal Combustion Engine (SICE) (Fire Pump) was manufactured by King-Knight Company; was installed in 1966; and has a design capacity of 1.22 MMBtu/hr.

In order to comply with NO_x RACT requirements, Huhtamaki accepted license restrictions of hours of operation for the emergency diesel unit to maintain NO_x emissions under 10 tons per year the diesel unit, and thus exempt the units from any requirements for NO_x emission control.

Streamlining

Opacity

Huhtamaki accepts streamlining for opacity requirements. Chapter 101, Section 2(A)(1), and Best Practical Treatment (BPT) requirements are applicable. The BPT opacity limit is more stringent. Therefore, only the more stringent BPT limit is included in this license.

Sulfur Dioxide

Huhtamaki accepts streamlining for sulfur dioxide requirements. Chapter 106 and BPT requirements are applicable. The BPT limit for sulfur dioxide is more stringent. Therefore, only the more stringent BPT sulfur dioxide limit is included in this license.

Periodic Monitoring

Periodic monitoring shall consist of recordkeeping of fuel use and hours of operation.

Based on the type of fuel used and hours of operation of the SICE unit and operating in a manner consistent with good air pollution control practices it is unlikely the SICE unit will exceed the opacity limits. Therefore, periodic monitoring by the source for opacity in the form of visible emission testing is not required. However, neither the EPA nor the state is precluded from performing its own testing and may take enforcement action for any violations discovered.

C. Parts Washers

Huhtamaki operates several cold cleaning parts washers.

Periodic Monitoring

Periodic monitoring for the parts washers shall consist of recordkeeping including records of solvent added and removed.

D. Process Dryers and Bead Blaster

The following sources are regulated for particulate matter.

Source	Date of Installation
Process Dryer, EU No. 8	1931, revised 1961
Process Dryer, EU No. 9	1931
Process Dryer, EU No. 10	1931
Process Dryer, EU No. 11	1970
Process Dryer, EU No. 12	1970
Process Dryer, EU No. 13	1959
Process Dryer, EU No. 14	1961-1962
Process Dryer, EU No. 15	1965-1966
Bead Blaster, EU No. 18	1976

Streamlining

Opacity

Huhtamaki accepts streamlining for opacity requirements. Chapter 101, Section 2(C), and Best Practical Treatment (BPT) requirements are applicable. The BPT opacity limit is more stringent. Therefore, only the more stringent BPT limit is included in this license.

Particulate Matter Emissions

Huhtamaki accepts streamlining for particulate matter requirements. Chapter 105, which limits particulate matter emissions from general process equipment, and BPT requirements are applicable. Meeting the Best Practical Treatment (BPT) opacity limits in this license meets Chapter 105 requirements.

Periodic Monitoring

Periodic monitoring shall consist of recordkeeping of production and all process and equipment malfunctions that may cause or may have caused an upward trend towards an increase on emissions of criteria pollutants, excluding minor smoldering and fires on the process line.

Based on maintenance and normal operation of the above process equipment and operating in a manner consistent with good air pollution control practices it is unlikely the process equipment will exceed the opacity limits. Therefore, periodic monitoring for opacity in the form of visible emissions testing is not required.

However, the EPA and the State may perform its own testing or require the source to perform testing, and either EPA and/or the State may take enforcement action for any violations discovered.

E. Sodium Hypochlorite Tank

Huhtamaki utilizes a 5,452 gallon sodium hypochlorite tank. Emissions from the tank are controlled by a scrubber on the vent stack. The scrubber is a polymisting Pad with a design capture and control efficiency of 99.49%.

Periodic Monitoring

Periodic monitoring shall consist of recordkeeping of production and all process and equipment malfunctions that may cause or may have caused an upward trend towards an increase on emissions of criteria pollutants.

F. Fugitive Emissions

Fugitive particulate matter emission sources at Huhtamaki include paved and unpaved surfaces.

Periodic Monitoring

Based on the best management practices, it is unlikely the fugitive emission sources will exceed the opacity limits. Therefore, periodic monitoring for opacity in the form of visible emissions testing is not required. However, neither the EPA nor the State is precluded from performing its own testing and may take enforcement action for any violations discovered.

G. Miscellaneous Emission units with Applicable Requirements

Miscellaneous emission units include various small fuel burning sources.

Streamlining

Opacity

Huhtamaki accepts streamlining for opacity requirements. Chapter 101, Section 2(A)(1), and Best Practical Treatment (BPT) requirements are applicable. The BPT opacity limit is more stringent. Therefore, only the more stringent BPT limit is included in this license.

Periodic Monitoring

The miscellaneous emission units are subject to generally applicable requirements, and a regular program of monitoring will not significantly enhance the ability of the permit to assure compliance with the general applicable requirement. Therefore, no monitoring is required for these units.

H. Facility Emissions

Total Annual Emissions for the Facility
(used to calculate the annual license fee)

Pollutant	TPY**
PM	63.1
PM ₁₀	63.1
SO ₂	879.2
NO _x	212.6
CO	14.1
VOC	4.1

** The total annual emissions indicate the combined emissions from only the boilers.

III. AIR QUALITY ANALYSIS

A. Overview

A combination of screening and refined modeling was performed to show that emissions from Huhtamaki, in conjunction with other sources, will not cause or contribute to violations of Maine Ambient Air Quality Standards (MAAQS) for SO₂, PM₁₀, NO₂ or CO.

MEDEP has determined that Huhtamaki consumes only NO₂ increment, therefore a Class I and Class II NO₂ increment analysis was performed.

B. Model Inputs

The ISCST3 model was used in refined mode to address standards in all areas. Although ISCST3 is designed to predict concentrations in both simple and complex terrain, only the simple terrain option was used in this analysis. In addition, the VALLEY mode of the SCREEN-3 model (SCREEN3-VM) was used to evaluate impacts in intermediate and complex terrain (i.e., areas where terrain elevations exceed current stack-top elevations. Since all of the stacks at the Huhtamaki facility are greater the $H + 0.5L$ (where H is the height of the controlling structure and L is the lesser of the height or maximum projected width of that structure), no cavity analysis was performed.

All modeling was performed in accordance with all applicable requirements of the Maine Department of Environmental Protection, Bureau of Air Quality (MEDEP-BAQ) and the United States Environmental Protection Agency (USEPA).

A valid 5-year hourly off-site meteorological database was used in the ISCST3 refined modeling analysis. Wind data was collected at a height of 15.00 meters at the Augusta Airport DEP meteorological monitoring site during the 5-year period 1984-1988. Each year of meteorological data met the 90% data recovery requirement, both singularly and jointly. Missing data were interpolated or coded as missing, per EPA guidance. Hourly cloud cover, ceiling height and wind data measured at the 15-meter level, also collected at the Augusta Airport DEP site, were used to determine stability. Hourly mixing heights were derived from Portland NWS surface and upper air data.

Point-source parameters, used in the modeling for Huhtamaki and other nearby sources, are listed in Tables IV-1. The modeling accounted for the potential of building wake effects on emissions from all modeled stacks that are below their respective formula GEP stack heights.

TABLE IV-1 : Point Source Stack Parameters

Facility/Stack	Stack Base Elevation (m)	Stack Height (m)	GEP Stack Height (m)	Stack Diameter (m)	UTM Easting (km)	UTM Northing (km)
<u>CURRENT/PROPOSED</u>						
Huhtamaki						
Stack #1 (Boilers #2,#3)	30.50	31.70	28.96	1.88	451.560	4935.940
Stack #3 (Boilers #4,#5)	30.50	31.70	28.96	1.68	451.560	4935.940
Colby College						
Stack #1	76.50	22.86	22.86	1.52	447.370	4934.950
MGMC – Seton Unit						
Stack #1	68.27	33.50	76.70	1.20	447.680	4932.780
MGMC – Thayer Unit						
Stack #1	36.27	40.00	58.75	0.91	448.580	4934.670
Kimberly Clark						
Stack #1	33.50	68.60	68.60	3.66	450.500	4933.320
Cascade Woolen						
Stack #1	45.48	23.04	59.83	1.07	443.734	4933.012
<u>1987 BASELINE</u>						
Huhtamaki						
Stack #1	30.50	31.70	28.96	1.88	451.560	4935.940
Stack #2	30.50	31.70	28.96	1.68	451.560	4935.940
Stack #3	30.50	31.70	28.96	1.88	451.560	4935.940

The emission parameters for Huhtamaki and other nearby sources for MAAQS and increment modeling are listed in Table IV-2. Emission parameters for Huhtamaki are based on the maximum license allowed operating configuration. For the purposes of determining PM₁₀ and NO₂ impacts, all PM₁₀ and NO_x emissions were conservatively assumed to convert to PM₁₀ and NO₂, respectively.

TABLE IV-2 : Stack Emission Parameters

Facility/Stack	Averaging Periods	SO ₂ (g/s)	PM ₁₀ (g/s)	NO ₂ (g/s)	CO (g/s)	Stack Temp (K)	Stack Velocity (m/s)
<u>MAXIMUM LICENSE ALLOWED</u>							
Huhtamaki							
Stack #1 (Boilers #2, #3)	All	13.12	1.10	3.70	0.27	550.00	4.37
Stack #3 (Boilers #4, #5)	All	24.40	2.06	5.48	0.24	495.00	8.63
Colby College							
Stack #1	All	4.90	0.84	3.36	nm	450.00	8.52
MGMC- Seton Unit							
Stack #1	All	3.48	0.24	0.79	nm	450.00	1.59
MGMC – Thayer Unit							
Stack #1	All	5.30	0.36	1.21	nm	450.00	4.23
Kimberly Clark							
Stack #1	All	189.00	19.80	45.20	nm	477.00	15.00
Cascade Woolen							
Stack #1	All	9.38	0.90	2.24	nm	450.00	5.07
<u>1987 BASELINE</u>							
Huhtamaki							
Stack #1 (Boiler #2)	All	nm	nm	0.92	nm	550.00	1.63
Stack #2 (Boiler #5)	All	nm	nm	2.04	nm	450.00	2.99
Stack #3 (Boiler #4)	All	nm	nm	0.59	nm	550.00	2.19

Key: nm = not modeled

C. Applicant's Modeled Impacts

ISCST3 refined modeling (in simple terrain mode), using five years of meteorological data, and SCREEN3-VM screening modeling was performed for various operating scenarios that represented maximum, typical and minimum operations for Huhtamaki. The model results for the applicant alone in simple and complex terrain are shown in Tables IV-3 and IV-4, respectively. All SO₂, PM₁₀ and NO₂ averaging period impacts were significant in both the simple and complex terrain analyses. It was demonstrated that Huhtamaki would have no significant impacts for CO in either simple or complex terrain; therefore, no further analysis was required for these pollutant/terrain combinations.

TABLE IV-3: Maximum ISCST3 (Simple) Impacts from Huhtamaki Alone

Pollutant	Averaging Period	Max Impact ($\mu\text{g}/\text{m}^3$)	Receptor UTM E (km)	Receptor UTM N (km)	Receptor Elevation (m)	Class II Significance Level ($\mu\text{g}/\text{m}^3$)
SO ₂	3-hour	325.56	448.560	4934.940	45.72	25
	24-hour	132.80	452.100	4935.500	44.19	5
	Annual	13.72	452.100	4935.700	45.72	1
PM ₁₀	24-hour	11.18	452.360	4935.340	33.52	5
	Annual	0.95	452.760	4935.140	57.91	1
NO ₂	Annual	2.90	451.360	4937.940	51.81	1
CO	1-hour	21.00*	NA	NA	NA	2000
	8-hour	14.70*	NA	NA	NA	500

Key: * = SCREEN3-VM result

TABLE IV-4: Maximum SCREEN3-VM (Complex) Impacts from Huhtamaki Alone

Pollutant	Averaging Period	Max Impact ($\mu\text{g}/\text{m}^3$)	Receptor UTM E (km)	Receptor UTM N (km)	Receptor Elevation (m)	Class II Significance Level ($\mu\text{g}/\text{m}^3$)
SO ₂	3-hour	297.71	449.550	4936.950	92.96	25
	24-hour	132.31	449.550	4936.950	92.96	5
	Annual	26.46	449.550	4936.950	92.96	1
PM ₁₀	24-hour	11.15	449.550	4936.950	92.96	5
	Annual	2.23	449.550	4936.950	92.96	1
NO ₂	Annual	6.60	449.550	4936.950	92.96	1
CO	1-hour	1.30	449.550	4936.950	92.96	2000
	8-hour	0.86	449.550	4936.950	92.96	500

D. Combined Source Modeling

Because modeled impacts from Huhtamaki alone were greater than the significance levels for all SO₂, PM₁₀, NO₂ averaging periods, sources not explicitly included in the modeling analysis must be included by using representative background concentrations for the area. Background concentrations are derived from representative urban background data collected by MEDEP and are shown in Table IV-5.

TABLE IV-5: Background Concentrations

Pollutant	Averaging Period	Background Concentration ($\mu\text{g}/\text{m}^3$)
SO ₂	3-hour	145 ¹
	24-hour	67 ¹
	Annual	6 ¹
PM ₁₀	24-hour	52 ¹
	Annual	20 ¹
NO ₂	Annual	26 ²

Notes:

¹ Lewiston CKP Site

² Cape Elizabeth – PEOPL Site

MEDEP-BAQ identified other sources whose impacts would potentially be significant in Chinet's significant impact area. The other sources explicitly included in the combined source modeling are: Colby College, MGMC – Seton, MGMC – Thayer, Kimberly Clark and Cascade Woolen.

Table IV-6 summarizes maximum combined source impacts. The predicted impacts are added to the conservative background concentrations to demonstrate compliance with MAAQS. All combined source impacts for all pollutant/averaging periods were below their respective MAAQS. Because the impacts using this method meet MAAQS, no further MAAQS modeling for Huhtamaki needed to be performed.

TABLE IV-6 : ISCST3 (Simple/Complex Mode) Maximum Combined Sources Impacts

Pollutant	Averaging Period	Max Impact ($\mu\text{g}/\text{m}^3$)	Receptor UTM E (km)	Receptor UTM N (km)	Receptor Elevation (m)	Back-Ground ($\mu\text{g}/\text{m}^3$)	Max Total Impact ($\mu\text{g}/\text{m}^3$)	MAAQS ($\mu\text{g}/\text{m}^3$)
SO ₂	3-hour	1439.69*	443.500	4933.000	94.48	145	1584.69	1150
	24-hour	295.53*	443.500	4933.000	94.48	67	362.53	230
	Annual	32.42	448.500	4935.000	60.96	6	38.42	57
PM ₁₀	24-hour	28.54	443.500	4933.000	94.48	52	80.54	150
	Annual	2.27	448.500	4935.000	60.96	20	22.27	40
NO ₂	Annual	7.58	448.000	4934.000	60.96	26	33.58	100

Key: * = The applicant did not cause or significantly contribute to this or any MAAQS violations.

E. Increment

Huhtamaki's maximum increment impacts were predicted using ISCST3 (refined) modeling in simple terrain and SCREEN3-VM (screening) in complex terrain. For addressing increment impacts in intermediate terrain (i.e., terrain above stack-top and below plume centerline), the ISCST3 and SCREEN3-VM were run individually, and

the higher of the two increment impacts chosen. The maximum license allowed emissions limits were used in the increment analysis.

Results of the single source Class II increment analyses are shown in TABLE IV-7. All NO₂ averaging period predicted increment impacts were below increment standards. It has been determined by MEDEP that no other area sources consume NO₂ increment. Therefore, no combined source increment analysis was performed. Because impacts using this method meet increment standards, no further Class II increment modeling for Huhtamaki needs to be performed.

TABLE IV-7 : Class II Increment Consumption – Huhtamaki Alone

Pollutant	Averaging Period	Max Impact (µg/m³)	Receptor UTM E (km)	Receptor UTM N (km)	Receptor Elevation (m)	Model	Class II Increment (µg/m³)
NO ₂	Annual	3.10	449.550	4936.950	92.96	SCREEN3	25

F. Class I Impacts

Since it has been determined that Huhtamaki does consume NO₂ increment and the nearest Class I area is approximately 75 kilometers away, a Class I increment analysis was performed.

Results of the Class I increment analysis, are shown in tables IV-8. All NO₂ averaging period predicted increment impacts were below the Class I significance level. Because the predicted impacts meet increment standards, no further Class I increment modeling needs to be performed.

TABLE IV-8 : Class I Increment Consumption in Acadia National Park – Huhtamaki Alone

Pollutant	Averaging Period	Max Impact (µg/m³)	Receptor UTM E (km)	Receptor UTM N (km)	Receptor Elevation (m)	Class I Significance	Class I Increment (µg/m³)
NO ₂	Annual	0.024	530.350	4879.450	112.77	0.10	2.5

G. Summary

It has been demonstrated that emissions from Huhtamaki, in conjunction with other sources, will not cause or contribute to violations of Maine Ambient Air Quality Standards (MAAQS) for SO₂, PM₁₀, NO₂ or CO or to Class I or Class II increments for NO₂.

ORDER

Based on the above Findings and subject to conditions listed below the Department concludes that the emissions from this source:

- Will receive Best Practical Treatment,
- Will not violate applicable emission standards,
- Will not violate applicable ambient air quality standards in conjunction with emissions from other sources.

The Department hereby grants the Part 70 License A-416-70-A-I, subject to the following conditions:

For each standard and special condition which is state enforceable only, state-only enforceability is designated with the following statement: *Enforceable by State-only*. All federally enforceable and State-only enforceable conditions in existing air licenses previously issued to Huhtamaki (formerly licensed as The Chinnet Company) pursuant to the Department's preconstruction permitting requirements in Chapters 108 or 115 have been incorporated into this Part 70 license, except for such conditions that MEDEP has determined are obsolete, extraneous or otherwise environmentally insignificant, as explained in the findings of fact accompanying this permit. As such the conditions in this license supercede all previously issued air license conditions.

Federally enforceable conditions in this Part 70 license must be changed pursuant to the applicable requirements in Chapter 115 for making such changes and pursuant to the applicable requirements in Chapter 140.

Standard Statements

- (1) Approval to construct shall become invalid if the source has not commenced construction within eighteen (18) months after receipt of such approval or if construction is discontinued for a period of eighteen (18) months or more. The Department may extend this time period upon a satisfactory showing that an extension is justified, but may condition such extension upon a review of either the control technology analysis or the ambient air quality standards analysis, or both;
- (2) The Part 70 license does not convey any property rights of any sort, or any exclusive privilege;
- (3) All terms and conditions are enforceable by EPA and citizens under the CAA unless specifically designated as state enforceable.

- (4) The licensee may not use as a defense in an enforcement action that the disruption, cessation, or reduction of licensed operations would have been necessary in order to maintain compliance with the conditions of the air emission license;
- (5) Notwithstanding any other provision in the State Implementation Plan approved by the EPA or Section 114(a) of the CAA, any credible evidence may be used for the purpose of establishing whether a person has violated or is in violation of any statute, regulation, or Part 70 license requirement.
- (6) Compliance with the conditions of this Part 70 license shall be deemed compliance with any Applicable requirement as of the date of license issuance and is deemed a permit shield, provided that:
 - (a) Such Applicable and state requirements are included and are specifically identified in the Part 70 license, except where the Part 70 license term or condition is specifically identified as not having a permit shield; or
 - (b) The Department, in acting on the Part 70 license application or revision, determines in writing that other requirements specifically identified are not applicable to the source, and the Part 70 license includes the determination or a concise summary, thereof.

Nothing in this section or any Part 70 license shall alter or effect the provisions of Section 303 of the CAA (emergency orders), including the authority of EPA under Section 303; the liability of an owner or operator of a source for any violation of Applicable requirements prior to or at the time of permit issuance; or the ability of EPA to obtain information from a source pursuant to Section 114 of the CAA.

The following requirements have been specifically identified as not applicable based upon information submitted by the licensee in an application dated October 27, 1997.

SOURCE	CITATION	DESCRIPTION	BASIS FOR DETERMINATION
Facility	MEDEP Chapter 132	Standards for Graphic Arts – Rotogravure and Flexography	Huhtamaki does not operate rotogravure printing presses.
Facility	40 CFR Part 63, Subpart KK	Standards for Graphic Arts – Rotogravure and Flexography	Huhtamaki does not operate rotogravure printing presses.
Facility	Chapter 134	VOC RACT	Paper machines are exempt from VOC RACT (Section 1.C.7) PTE from other areas is <40 TPY
Stationary Internal Combustion Engine (SICE)	Chapter 138	NOx RACT	SICE is exempt from this regulation in accordance with section 1.B of Chapter 138
Boilers #2, #3, #4 & #5	40 CFR Part 60, Subpart Dc	NSPS for Small Industrial-Commercial Steam Generating Units	Boilers were constructed prior to applicability date of June 9, 1989
Facility	40 CFR Part 63, Subpart S	NESHAP for Pulp and Paper	Facility is not a major source of HAPs and does not use chlorinated compounds to bleach pulp.

- (7) The Part 70 license shall be reopened for cause by the Department or EPA, prior to the expiration of the Part 70 license, if:
- (a) Additional Applicable requirements under the CAA become applicable to a Part 70 major source with a remaining Part 70 license term of 3 or more years. However, no opening is required if the effective date of the requirement is later than the date on which the Part 70 license is due to expire, unless the original Part 70 license or any of its terms and conditions has been extended pursuant to Chapter 140;
 - (b) Additional requirements (including excess emissions requirements) become applicable to a Title IV source under the acid rain program. Upon approval by EPA, excess emissions offset plans shall be deemed to be incorporated into the Part 70 license;
 - (c) The Department or EPA determines that the Part 70 license contains a material mistake or that inaccurate statements were made in establishing the emissions standards or other terms or conditions of the Part 70 license; or
 - (d) The Department or EPA determines that the Part 70 license must be revised or revoked to assure compliance with the Applicable requirements.

The licensee shall furnish to the Department within a reasonable time any information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the Part 70 license or to determine compliance with the Part 70 license.

- (8) No license revision or amendment shall be required, under any approved economic incentives, marketable licenses, emissions trading and other similar programs or processes for changes that are provided for in the Part 70 license.

Standard Conditions

- (1) Employees and authorized representatives of the Department shall be allowed access to the licensee's premises during business hours, or any time during which any emissions units are in operation, and at such other times as the Department deems necessary for the purpose of performing tests, collecting samples, conducting inspections, or examining and copying records relating to emissions and this license (Title 38 MRSA §347-C);
- (2) The licensee shall acquire a new or amended air emission license prior to commencing construction of a modification, unless specifically provided for in Chapter 140;
- (3) The licensee shall establish and maintain a continuing program of best management practices for suppression of fugitive particulate matter during any period of construction, reconstruction, or operation which may result in fugitive dust, and shall submit a description of the program to the Department upon request;
- (4) The licensee shall pay the annual air emission license fee to the Department, calculated pursuant to Title 38 MRSA §353.
- (5) The licensee shall maintain and operate all emission units and air pollution control systems required by the air emission license in a manner consistent with good air pollution control practice for minimizing emissions;
- (6) The licensee shall retain records of all required monitoring data and support information for a period of at least six (6) years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the Part 70 license. The records shall be submitted to the Department upon written request or in accordance with other provisions of this license;

- (7) The licensee shall comply with all terms and conditions of the air emission license. The submission of notice of intent to reopen for cause by the Department, the filing of an appeal by the licensee, the notification of planned changes or anticipated noncompliance by the licensee, or the filing of an application by the licensee for the renewal of a Part 70 license or amendment shall not stay any condition of the Part 70 license.
- (8) In accordance with the Department's air emission compliance test protocol and 40 CFR Part 60 or other method approved or required by the Department, the licensee shall:
- (a) perform stack testing under circumstances representative of the facility's normal process and operating conditions:
 - (i) within sixty (60) calendar days of receipt of a notification to test from the Department or EPA, if visible emissions, equipment operating parameters, staff inspection, air monitoring or other cause indicate to the Department that equipment may be operating out of compliance with emission standards or license conditions;
 - (ii) to demonstrate compliance with the applicable emission standards; or
 - (iii) pursuant to any other requirement of this license to perform stack testing.
 - (b) install or make provisions to install test ports that meet the criteria of 40 CFR Part 60, Appendix A, and test platforms, if necessary, and other accommodations necessary to allow emission testing; and
 - (c) submit a written report to the Department within thirty (30) days from date of test completion.
- (9) If the results of a stack test performed under circumstances representative of the facility's normal process and operating conditions indicates emissions in excess of the applicable standards, then:
- (a) within thirty (30) days following receipt of such test results, the licensee shall re-test the non-complying emission source under circumstances representative of the facility's normal process and operating conditions and in accordance with the Department's air emission compliance test protocol and 40 CFR Part 60 or other method approved or required by the Department; and
 - (b) the days of violation shall be presumed to include the date of stack test and each and every day of operation thereafter until compliance is demonstrated under normal and representative process and operating conditions, except to

the extent that the facility can prove to the satisfaction of the Department that there were intervening days during which no violation occurred or that the violation was not continuing in nature; and

- (c) the licensee may, upon the approval of the Department following the successful demonstration of compliance at alternative load conditions, operate under such alternative load conditions on an interim basis prior to a demonstration of compliance under normal and representative process and operating conditions.
- (10) The licensee shall maintain records of all deviations from license requirements. Such deviations shall include, but are not limited to malfunctions, failures, downtime, and any other similar change in operation of air pollution control systems or the emission unit itself that is not consistent with the terms and conditions of the air emission license.
- a. The licensee shall notify the Commissioner within 48 hours of a violation in emission standards and/or a malfunction or breakdown in any component part that causes a violation of any emission standard, and shall report the probable cause, corrective action, and any excess emissions in the units of the applicable emission limitation;
- b. The licensee shall submit a report to the Department on a quarterly basis if a malfunction or breakdown in any component part causes a violation of any emission standard, together with any exemption requests.
- Pursuant to 38 MRSA § 349(9), the Commissioner may exempt from civil penalty an air emission in excess of license limitations if the emission occurs during start-up or shutdown or results exclusively from an unavoidable malfunction entirely beyond the control of the licensee and the licensee has taken all reasonable steps to minimize or prevent any emission and takes corrective action as soon as possible. There may be no exemption if the malfunction is caused, entirely or in part, by poor maintenance, careless operation, poor design or any other reasonably preventable condition or preventable equipment breakdown. The burden of proof is on the licensee seeking the exemption under this subsection.
- c. All other deviations shall be reported to the Department in the facility's semiannual report.
- (11) Upon the written request of the Department, the licensee shall establish and maintain such records, make such reports, install, use, and maintain such monitoring equipment, sample such emissions (in accordance with such methods, at such locations, at such intervals, and in such manner as the Department shall

prescribe), and provide other information as the Department may reasonably require to determine the licensee's compliance status.

- (12) The licensee shall submit semiannual reports of any required periodic monitoring. All instances of deviations from Part 70 license requirements must be clearly identified in such reports. All required reports must be certified by a responsible official.
- (13) The licensee shall submit a compliance certification to the Department and EPA at least annually, or more frequently if specified in the applicable requirement or by the Department. The compliance certification shall include the following:
 - (a) The identification of each term or condition of the Part 70 license that is the basis of the certification;
 - (b) The compliance status;
 - (c) Whether compliance was continuous or intermittent;
 - (d) The method(s) used for determining the compliance status of the source, currently and over the reporting period; and
 - (e) Such other facts as the Department may require to determine the compliance status of the source;

SPECIAL CONDITIONS

- (14) **Boiler No. 2 and No. 3**
 - A. Huhtamaki is licensed to operate Boiler No. 2 and No. 3 with a heat input rate of 29.3 MMBtu/hr each. [MEDEP Chapter 140, BPT]
 - B. Huhtamaki is licensed to fire fuel oil (#6 fuel oil and specification waste oil) in boilers No. 2 and 3 with a maximum sulfur content not to exceed 1.7% by weight. [MEDEP Chapter 140, BPT]
 - C. Huhtamaki shall perform an annual tune-up on boiler No. 2 and No. 3, between September 1 and October 31 each year. Huhtamaki shall maintain the following records, in accordance with Chapter 138 Section 3(L)(2):
 - 1. Record of the annual tune-ups;
 - 2. A tune-up procedure file must be kept on-site and made available to the Department upon request;
 - 3. An oxygen/carbon monoxide curve or an oxygen /smoke curve must be kept on file;
 - 4. Once the optimum excess oxygen setting has been determined, Huhtamaki shall verify monthly setting remains at that value; and

5. If the minimum oxygen level found is substantially higher than the value provided by the combustion unit manufacturer, Huhtamaki must improve the fuel and air mixing, thereby allowing operation with less air.

[MEDEP Chapter 138, NO_x RACT]

- D. Emissions from boiler No. 2 and No. 3 shall each not exceed the following limits:

Pollutant	Lb/MMBtu	Lb/hr	Origin & Authority	Enforceability
PM	0.15	4.4	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
PM ₁₀	0.15	4.4	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
SO ₂	-	52	MEDEP Chapter 140 BPT	Enforceable by State-only
NO _x	-	13.2	MEDEP Chapter 140 BPT	Enforceable by State-only
CO	-	1.0	MEDEP Chapter 140 BPT	Enforceable by State-only
VOC	-	0.25	MEDEP Chapter 140 BPT	Enforceable by State-only

- E. Huhtamaki shall operate boilers No. 2 and 3 such that the visible emissions from boilers No. 2 and 3 do not exceed 30% opacity on a six (6) minute block average basis, except for three (3) six (6) minute block averages in a 3-hour block period. [MEDEP Chapter 140, BPT]

(15) Boiler No. 4

- A. Huhtamaki is licensed to operate boiler No. 4 with a heat input rate of 44 MMBtu/hr. [MEDEP Chapter 140, BPT]
- B. Huhtamaki is licensed to fire fuel oil (#6 fuel oil and specification waste oil) in boiler No. 4 with a maximum sulfur content not to exceed 1.7% by weight. [MEDEP Chapter 140, BPT]
- C. Boiler No. 4 shall not operate unless it vents to Stack #3 (east stack).
- D. Boiler No. 4 shall comply with Chapter 138 Section 3(L)(1) & (2) if the boiler operates at greater than 2% of its annual capacity factor.
- E. Fuel use in boiler No. 4 shall be documented by recording the gal/hr of #6 fuel oil fired in the boiler in a daily log to be kept on site at all times. If and when the boiler operates above 2% of its annual capacity factor, Huhtamaki shall within 90 days comply with MEDEP Chapter 138 Section 3(L) and all recordkeeping requirements.
- F. Emissions from boiler No. 4 shall not exceed the following limits:

Pollutant	Lb/MMBtu	Lb/hr	Origin & Authority	Enforceability
PM	0.15	6.6	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
PM ₁₀	0.15	6.6	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
SO ₂	-	78.3	MEDEP Chapter 140 BPT	Enforceable by State-only
NO _x	0.45	19.8	MEDEP Chapter 140 BPT	Enforceable by State-only
CO	-	1.5	MEDEP Chapter 140 BPT	Enforceable by State-only
VOC	-	0.40	MEDEP Chapter 140 BPT	Enforceable by State-only

G. Huhtamaki shall operate boiler No. 4 such that the visible emissions from stack #2 do not exceed 30% opacity on a six (6) minute block average basis, except for three (3) six (6) minute block averages in a 3-hour block period. [MEDEP Chapter 140, BPT]

(16) Boiler No. 5

A. Huhtamaki is licensed to operate boiler No. 5 with a heat input rate of 64.8 MMBtu/hr. [MEDEP Chapter 140, BPT]

B. Huhtamaki is licensed to fire fuel oil (#6 fuel oil and specification waste oil) in boiler No. 5 with a maximum sulfur content not to exceed 1.7% by weight. [MEDEP Chapter 140, BPT]

C. Huhtamaki shall operate boiler No. 5 with low-NO_x burner technology. [MEDEP Chapter 138]

D. Emissions from boiler No. 5 shall not exceed the following limits:

Pollutant	Lb/MMBtu	Lb/hr	Origin & Authority	Enforceability
PM	0.15	9.7	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
PM ₁₀	0.15	9.7	MEDEP Chapter 140 BPT	Lb/hr limit enforceable by State-only
SO ₂	-	115.1	MEDEP Chapter 140 BPT	Enforceable by State-only
NO _x	0.40	24	MEDEP Chapter 140 BPT	Enforceable by State-only
CO	-	2.2	MEDEP Chapter 140 BPT	Enforceable by State-only
VOC	-	0.55	MEDEP Chapter 140 BPT	Enforceable by State-only

E. Huhtamaki shall operate boiler No. 5 such that the visible emissions from stack #2 do not exceed 30% opacity on a six (6) minute block average basis, except for three (3) six (6) minute block average in a 3-hour block period. [MEDEP Chapter 140]

- F. Huhtamaki shall perform annual NO_x emission stack testing on boiler No. 5 by May 31 every year. Huhtamaki shall submit a written report of the NO_x emission test results and possible scenarios based on those results to reduce NO_x emissions by June 30 each year.

Huhtamaki may apply to amend the license to reduce the frequency of stack testing upon successful compliance demonstration of two consecutive annual stack tests. [MEDEP Chapter 138]

- G. Compliance with the particulate matter emission limits shall be demonstrated by emission testing once every two years using EPA Method 5. [MEDEP Chapter 140, BPT]

(17) Annual Fuel Use Cap for Boilers

For boilers No. 2, 3, 4, and 5, the total combined annual fuel use including #6 fuel oil with a sulfur content not to exceed 1.7% by weight and specification waste oil shall not exceed 5.6 million gallons per year (12-month rolling total). *Enforceable by State-only* [MEDEP Chapter 140, BPT]

(18) Recordkeeping [MEDEP Chapter 140, BPT]

Boilers No. 2, 3, 4, and 5:

- A. Huhtamaki is licensed to fire #6 fuel oil and specification waste oil in boilers No. 2, 3, 4, and 5. Only waste oil meeting the criteria “specification” waste oil (as defined in the “Waste Oil Management Rules”) shall be used in boilers No. 2, 3, 4 and 5. *Enforceable by State-only*
- B. For the specification waste oil fired, Huhtamaki shall maintain records of a representative sample of the waste oil utilized demonstrating that the waste oil meets the allowable level for the constituents and property in accordance with the Department’s “Waste Oil Management Rules”. A log shall be kept recording the quantity of waste oil fired in the boilers, and a representative waste oil analysis will be submitted to the Department upon request. *Enforceable by State-only*
- C. Huhtamaki shall maintain daily records of the amount of fuel oil fired in boiler No. 4.
- D. Huhtamaki shall maintain monthly records of the total gallons of fuel oil (#6 fuel oil and specification waste oil) fired in boilers No. 2, 3, 4, and 5. The records shall indicate the quantity of fuel consumed per month and the percent (%) sulfur and percent (%) nitrogen content of the fuel by weight (demonstrated by the purchase receipts from the supplier).

- (19) **Emergency Stationary Internal Combustion Engine (SICE)**
- A. Huhtamaki is licensed to operate a 1.22 MMBtu/hr fire pump.
 - B. The diesel fuel fired in the SICE unit shall not exceed a sulfur content of 0.05% by weight. Huhtamaki shall maintain records of purchase receipts to document compliance with the low sulfur requirement. [MEDEP Chapter 140, BPT]
 - C. The fire pump shall not exceed 1,000 hours of operation per year on a 12-month rolling total basis. [MEDEP Chapter 138, NO_x RACT]
 - D. Huhtamaki shall operate an hour meter on the fire pump and keep a log of hours of operation. [MEDEP Chapter 140, BPT]
 - E. The fire pump shall not exceed 30% opacity on a six (6) minute block average basis, except for two (2) six (6) minute block averages in a 3-hour block period. [MEDEP Chapter 140, BPT]
- (20) **Process Steam Dryers**
- A. Visible emissions from process dryers No. 8 - 15 shall not exceed 10% opacity on a six (6) minute block average basis.
 - B. Huhtamaki shall maintain production records and records of all process and equipment malfunctions that might increase emissions.
[MEDEP Chapter 140, BPT]
- (21) **Bead Blaster**
- A. Visible emissions from the bead blaster shall not exceed 10% opacity on a six (6) minute block average basis.
 - B. Huhtamaki shall maintain production records and records of all process and equipment malfunctions that might increase emissions.
[MEDEP Chapter 140, BPT]
- (22) **Sodium Hypochlorite Tank**
- A. Huhtamaki shall maintain monthly records of sodium hypochlorite throughput (gallons).
 - B. Huhtamaki shall control sodium hypochlorite tank emissions with a scrubber on the vent stack.
 - C. Huhtamaki shall maintain a log detailing all control equipment malfunctions and all maintenance on the tank scrubber. The log shall include the date and nature of all scrubber failures.
- (23) **Parts Washers**
- Huhtamaki shall operate the parts washer in accordance with Chapter 130 and shall label the solvent parts washers with operational standards, equip the washer with cover if vapor pressure >15 mmHG at 100°F, close cover when not in use,

drain parts for 15 seconds or longer, shall not degrease porous material, keep drafts < 40 m/minute, repair leaks, and keep records of solvent added and removed. [MEDEP Chapter 130]

(24) **Fugitive Emissions**

Potential sources of fugitive PM emissions including paved and unpaved roadways shall be controlled when appropriate by wetting with water, with calcium chloride, or other methods as approved by the Bureau of Air Quality to prevent visible emissions in excess of 10% opacity on three (3) minute block average basis. [MEDEP Chapter 140, BPT]

(25) **Stack Testing**

A. All stack testing programs shall comply with all of the requirements of the MEDEP Compliance Test Protocol and with 40 CFR Part 60, as appropriate, or other methods approved by the MEDEP and EPA to test.

B. Unless otherwise explicitly required by this license, Huhtamaki shall conduct stack emission testing for criteria pollutants and opacity, and demonstrate compliance with the applicable standard, when requested by the Bureau of Air Quality. If so requested, Huhtamaki shall test the following sources within 60 days after receipt of notice from the Bureau of Air Quality:

- | | | |
|-----------------|-------------------------|-----------------|
| a. Boiler No. 2 | b. Boiler No. 3 | c. Boiler No. 4 |
| d. Boiler No. 5 | e. Process Steam Dryers | |

C. Huhtamaki shall conduct particulate matter testing (Method 5) and demonstrate compliance emission standards (PM and PM₁₀) once every two years on Boiler No. 5.

D. Huhtamaki shall conduct nitrogen oxide testing and demonstrate compliance with emission standards, by May 31 annually, on Boiler No. 5.
[MEDEP Chapter 140, BPT]

(26) **Semiannual Reporting**

The licensee shall submit semiannual reports every six months to the Bureau of Air Quality. The initial semiannual report is due July 30th, 2002, 30 days from the end of the second calendar quarter following the date of signature of this license.

A. Each semiannual report shall include a summary of the periodic monitoring required by this license.

B. All instances of deviations from license requirements and the corrective action taken must be clearly identified and provided to the Department in summary form for each six-month interval.

[MEDEP Chapter 140]

(27) **Annual Compliance Certification**

Huhtamaki shall submit an annual compliance certification to the Department in accordance with Condition (13) of this license. The initial annual compliance certification is due January 30th, 2002, with the submittal of the second semiannual report after the signature date of this license. [MEDEP Chapter 140]

(28) **Annual Emission Statement**

In accordance with MEDEP Chapter 137, the licensee shall annually report to the Department the information necessary to accurately update the State's emission inventory by means of:

- 1) Computer program and accompanying instructions supplied by the Department;
or
- 2) A written emission statement containing the information required in MEDEP Chapter 137.

Reports and questions should be directed to:

Attn: Criteria Emission Inventory Coordinator
Maine DEP
Bureau of Air Quality
17 State House Station
Augusta, ME 04333-0017

Phone: (207) 287-2437

The emission statement must be submitted by September 1.

(29) **Miscellaneous Emission Units**

<i>Emission Unit</i>	<i>Origin & Authority</i>	<i>Requirement Summary</i>
Fuel Burning Sources	Chapter 140, BPT	Visible emissions shall not exceed an opacity of 30 percent on a six (6) minute block average basis, for more than two (2) six (6) minute block averages in a 3-hour period

- (30) The licensee is subject to the following State regulations:

<i>Origin & Authority</i>	<i>Requirement Summary</i>
Chapter 102	Open Burning
Chapter 109	Emergency Episode Regulation
Chapter 110	Ambient Air Quality Standard
Chapter 116	Prohibited Dispersion Techniques

- (31) The licensee is subject to the following Federal regulations.

<i>Origin & Authority</i>	<i>Requirement Summary</i>
40 CFR Part 61, Subpart M	Compliance for demolition, reduction, waste disposal activities involving asbestos.
40 CFR Part 82, Subpart F	Recycling and Emissions Reduction for Protection of Stratospheric Ozone

- (32) **Certification by a Responsible Official**

All documents and reports (including semiannual reports and annual compliance certifications) required by this license to be submitted to the Bureau of Air Quality must be signed by a responsible official. [MEDEP Chapter 140]

- (33) This term of this license shall be five (5) years from the signature date below.

DONE AND DATED IN AUGUSTA, MAINE THIS DAY OF 2002.

DEPARTMENT OF ENVIRONMENTAL PROTECTION

By: _____
MARTHA G. KIRKPATRICK, COMMISSIONER

PLEASE NOTE ATTACHED SHEET FOR GUIDANCE ON APPEAL PROCEDURES

Date of initial receipt of application: October 27, 1997

Date of Application acceptance: October 27, 1997

Date filed with Board of Environmental Protection _____